

Work Order ID 58461

May 7, 2010 10:11:20 AM



Page 1

Item ID:	D3570-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket				Stop	
Start Date:	07/05/2010	Start Qty:	12.00			
Required Date:	14/05/2010	Req'd Qty:	12.00			
Reference:						
Cust Item ID:						
Customer:						

Approvals:	Process Plan:		Date:	10-5-07	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3570								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	GRAIN DIRECTION AS PER DWG								
	2-Deburr if necessary								


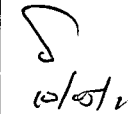
B 10-5-11

18

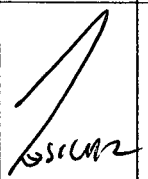
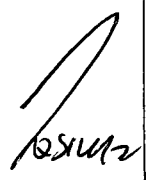

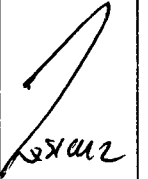
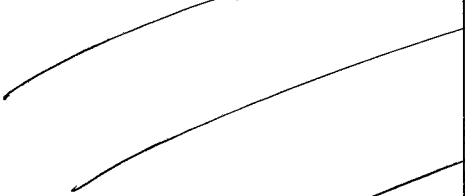
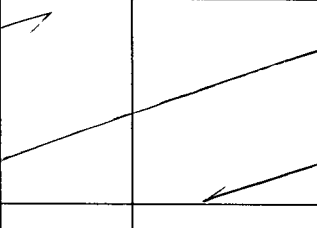
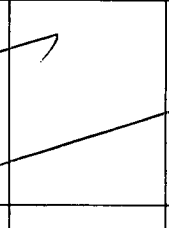
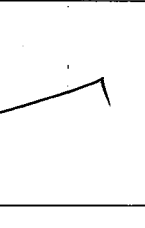

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-5-11

Dart Aerospace Ltd

W/O: 58461		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/11	120	Took Qty +1 for inspection template	S	10/05/11	4/	 1005-31	 10/05/11

Part No: D3570-3 PAR #: Fault Category: Small Probs. NCR: Yes No DQA: Date: 10.05.31
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/06/07

NCR: 58461		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/31	130	10 pieces holes are out of tolerance was suppose to be .328 are .343 Drill		Scrap + destroy No replace	M-d 10/05/31	S 10/05/31		
		bit were mit ^{up} R.C lost. did not use by bit i 1st hole checked.						

NOTE: Date & initial all entries

DART AEROSPACE LTD.

QUALITY SYSTEM INSTRUCTION: QSI 012

TITLE: INSPECTION

ISSUE: 13

DATE: April 1, 2008

PREPARED BY: Dale Trepanier

REVIEWED BY:

**Linda Lacelle
PRODUCTION MANAGER**

**Mike Petsche
DESIGN MANAGER**

APPROVED BY:

**Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE**

Work Order ID 58461

May 7, 2010 10:11:20 AM



Page 3

Item ID: D3570-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 BL 10-6-1

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:30
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:00

=> M 10/06/03

7 0

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BL 10-6-3

Work Order ID 58461

May 7, 2010 10:11:20 AM



Page 4

Item ID: D3570-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location JUSA

0.00



Packaging

Memo

0.00

Packaging

10-6-4sf 70

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07 JF

ME

10-6-7

Picklist Print

May 7, 2010 10:11:24 AM

Page 1

Work Order ID: 58461



Parent Item: D3570-3



Parent Item Name: Bracket

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

188.1500

0.087

1.6



B105-11

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT21

188.15

112476

19.2

113424

8.95

113608

96

114352

64

113424

18

DART AEROSPACE LTD		Work Order:	58761
Description: Bracket		Part Number:	D3570-3
Inspection Dwg: D3570	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

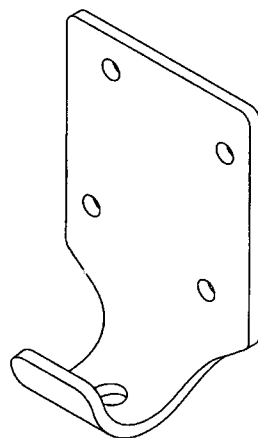
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.210	✓			
0.435	+/-0.010	.435	✓			
0.658	+/-0.010	.653	✓			
1.841	+/-0.010	1.838	✓			
2.064	+/-0.010	2.063	✓			
2.38	+/-0.030	2.383	✓			
0.359	+/-0.010	.359	✓			
0.557	+/-0.010	.557	✓			
1.943	+/-0.010	1.948	✓			
2.141	+/-0.010	2.141	✓			
5.25	+/-0.030	5.259	✓			
1.00	+/-0.030	1.009	✓			
0.125	+/-0.010	.123	✓			

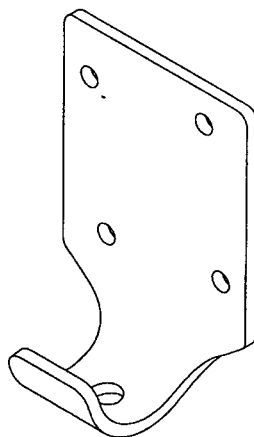
Measured by:	AB	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-11	Date:	10/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.09	New Issue	KJ	MA

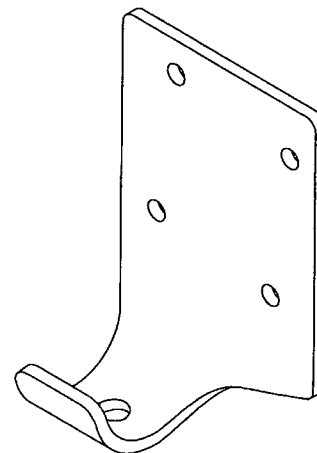
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58461
7810-5-07



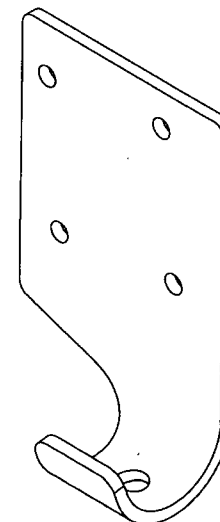
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



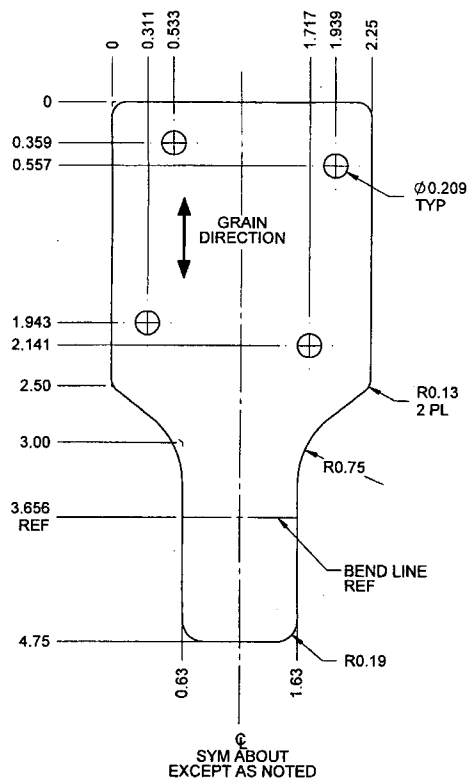
D3570-4 BRACKET

RELEASED
09/04/22

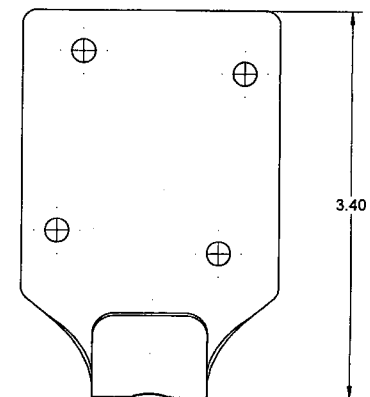
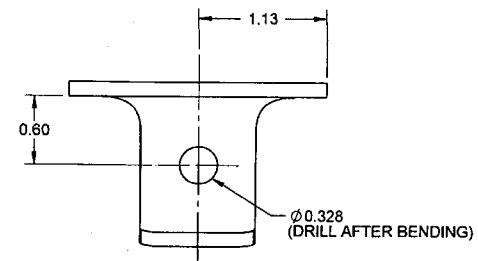
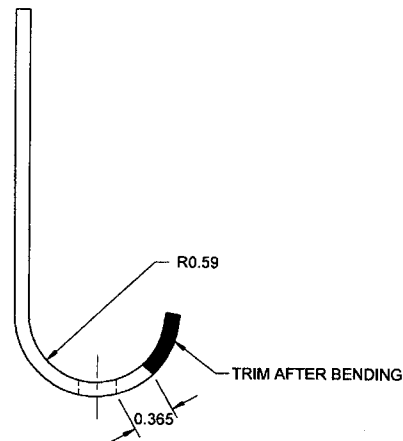
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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D3570-1F FLAT PATTERN

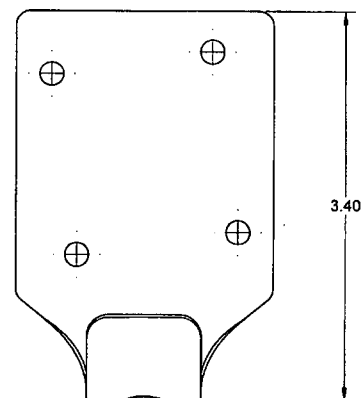
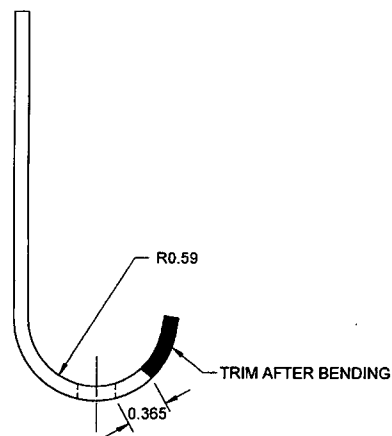
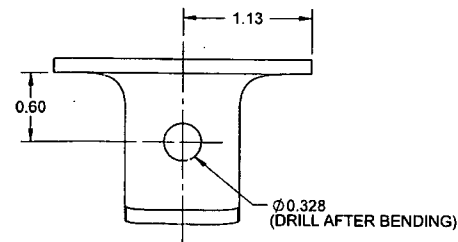


D3570-1 BRACKET
(MAKE FROM D3570-1F)

RELEASED
29/10/13 M

alo 58461

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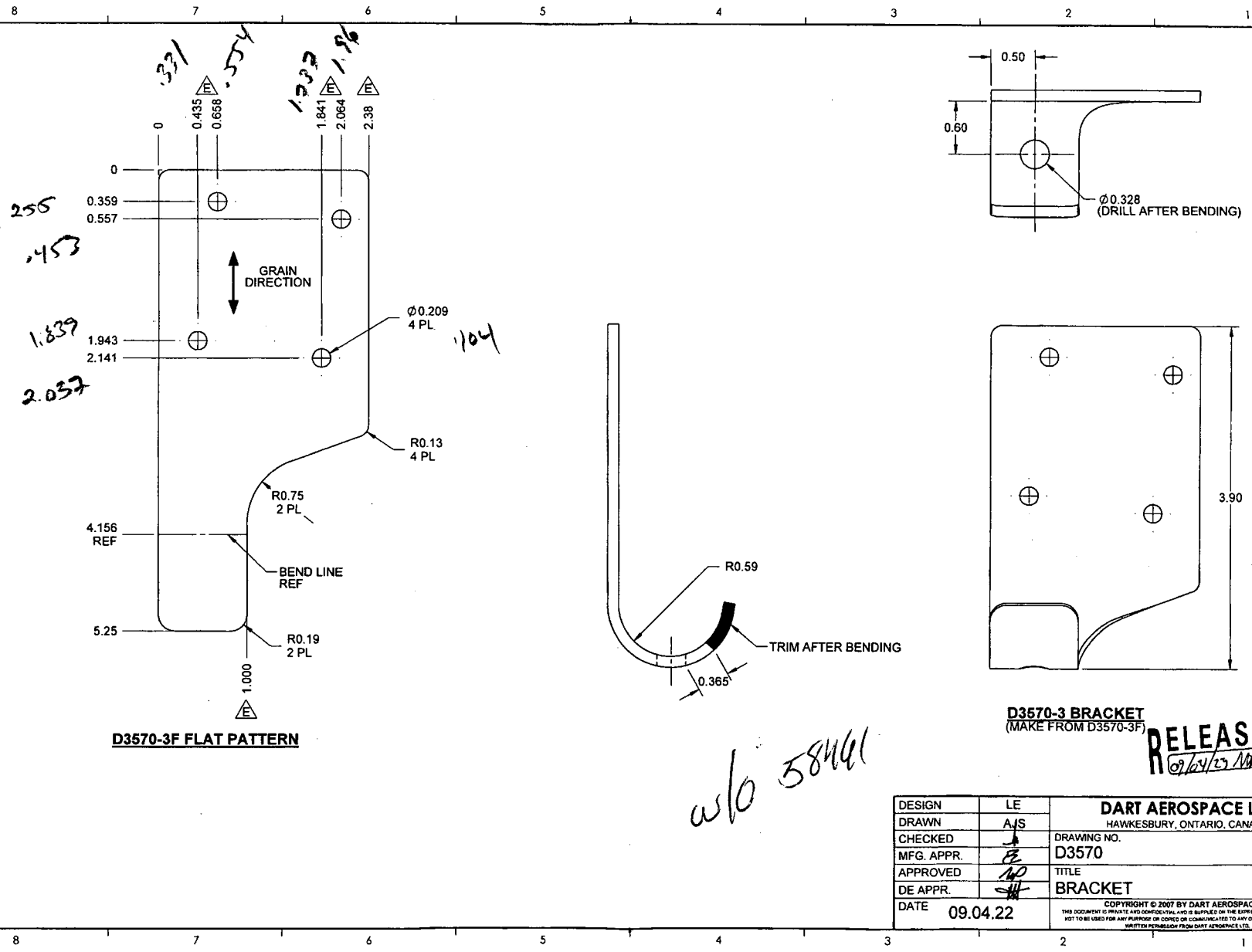


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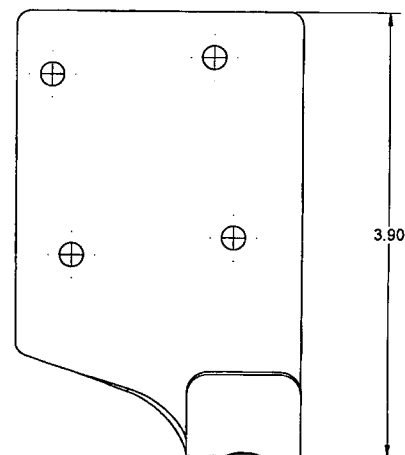
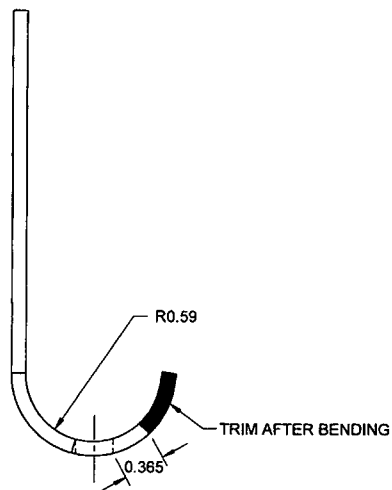
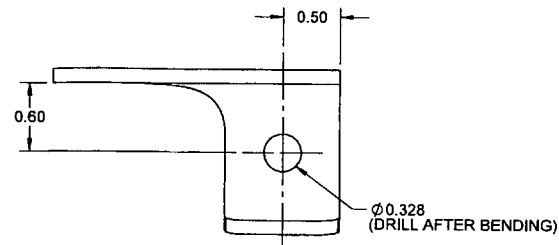
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09/04/22

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D3570-4 BRACKET
(MAKE FROM D3570-3F)

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